

ABSTRACT OF THE DISCLOSURE

A method of manufacturing fluted rolls, in particular for corrugating machines, comprises the steps of providing a fluted-roll blank which has a
5 central longitudinal axis and a longitudinal direction that is parallel thereto and a surface; providing a grinding device for grinding, on the surface, flutings that run in the longitudinal direction, with the flutings comprising heads and roots that are parallel to each other and are regularly and alternately distributed along the circumference of the surface; and grinding flut-
10 ing heads on the surface by means of the grinding device, with the fluting heads having the same cross-sectional curvature in the longitudinal direction.